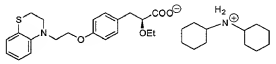
**[0052]** Mass m/z : 388 ($M^+ + 1$), 130 ($C_4H_{11}N_5$), 113 ($C_4H_8N_4$).

**[0053]** Anal:Calcd. : $C_{25}H_{36}N_6O_4S$, % C 58.12; % H 6.97%, % N 16.3, Found % C 57.95%, % H 6.61, % N 16.25.

**Example 3**

**Dicyclohexylamine salt of (-)-3-[4-[2-(3,4-dihydro-2H-1,4-benzothiazin-4-yl)ethoxy]phenyl]-2-ethoxy propanoic acid**



**[0054]** (-)-3-[4-[2-(3,4-Dihydro-2H-1,4-benzothiazin-4-yl)ethoxy]phenyl]-2-ethoxy propanoic acid (5.0g) and isopropanol (50 ml) were added to 250 ml four necked round bottom flask fitted with a mechanical stirrer and reflux condenser. The reaction was slowly heated to 45-55°C for complete dissolution of the glassy sticky mass. Dicyclohexylamine (2.33g) in isopropanol (20 ml) was added to the reaction mixture at 55-65°C in about 10 min. under stirring. The reaction mixture was maintained for reflux at 75-85°C for 12-14 h and monitored the progress of the reaction by TLC. The reaction mixture was concentrated on rotavapor bath at 45-55°C under reduced pressure to its half volume. The concentrated reaction mixture was cooled to RT and stirred for 2-3 h at room temperature. The precipitated product was filtered, dried at 60°C for 2-3 h to afford the pure dicylcohexylamine salt of (-)-3-[4-[2-(3,4-dihydro-2H-1,4-benzothiazin-4-yl)ethoxy]phenyl]-2-ethoxy propanoic acid as off-white crystalline solid (weighs about 5.1 g, yield : 70 %, m.p. : 110°C, purity by HPLC : 98-99 %).

**[0055]** IR (KBr) $cm^{-1}$ : 2932 (C-H aliphatic stretch), 2700-2200 (-$NH_3$ bands), 1582 (-COO stretch).

**[0056]** $^1H$ NMR (200 MHz, DMSO-$d_6$)δ : 1.0 (t, 3H, $CH_3$-$CH_2$-O), 1.2-2.0 (m, 22H, Cyclohexyl), 2.4-3.4 (m, 5H, -S-$CH_2$, Ar-$CH_2$, -CH-Ar), 3.45-4.0 (m, 7H, -$CH_2$-N-$CH_2$-, CHOEt, $CH_2$-$CH_2$-O-), 4.05 (q, 2H, -$OCH_2$), 6.5 (t, 1H, -$CH_2$-CH-), 6.7-7.4 (m, 8H, aromatic).

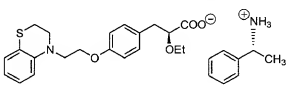
**[0057]** Mass m/z : 388 ($M^+ + 1$) 182 ($C_{12}H_{23}N$).

**[0058]** Anal : Calcd. : $C_{33}H_{48}N_2O_4S$, % C 69.71; % H 8.45%, % N 4.92, Found

% C 69.60%, % H 8.35, % N 4.75.

**Example 4**

**(R)-(+)-Methyl benzylamine salt of (-)-3-[4-[2-(3,4-dihydro-2H-1,4-benzothiazin-4-yl)ethoxy]phenyl]-2-ethoxy propanoic acid**



**[0059]** (-)-3-[4-[2-(3,4-Dihydro-2H-1,4-benzothiazin-4-yl)ethoxy]phenyl]-2-ethoxy propanoic acid (5.0 g) and isopropanol (50 ml) were added to 250 ml four necked round bottom flask fitted with a mechanical stirrer and reflux condenser. The reaction was slowly heated to 45-55°C for complete dissolution of the glassy sticky mass. R-(+)-Methyl benzylamine (1.5 g) in isopropanol (20 ml) was added to the reaction mixture of 55-65°C in about 10 min. under stirring. The reaction mixture was maintained for reflux at 75-85°C for 12-14 h and monitored the progress of the reaction. The reaction mixture was cooled to 25-35°C and stirred for 2-3 h. The precipitated product was filtered, dried at 60°C for 2-3 h to afford the pure (R)-(+)-methylbenzylamine salt of (-)-3-[4-[2-(3,4-dihydro-2H-1,4-benzothiazin-4-yl)ethoxy]phenyl]-2-ethoxypropanoic acid as off-white crystalline solid (weighs about 6 g, yield : 91%, m.p. 126-128°C; purity : 98.56 – 99.3 % by HPLC).

**[0060]** IR (KBr) $cm^{-1}$ : 2983-2856 (-$N^+$H stretch), 1637(-COO, Stretch).

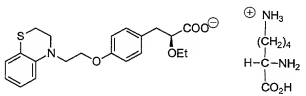
**[0061]** $^1$H NMR (200 MHz, $CD_3OD$)δ : 1.1 (t, 3H, $CH_3$-$CH_2$-O), 1.6 (d, 3H, $CH_3$-CH-), 2.6-3.4 (m, 5H, -S-$CH_2$-; Ar-$CH_2$, -CH-Ar), 3.45-4.0 (m, 7H, -$CH_2$N-$CH_2$-; -CH-OEt, $CH_2$-$CH_2$-O), 4.05 (q, 2H, -O-$CH_2$-) 6.5 (t, 1H, $CH_2CH$, -$CH_2$-N-$CH_2$), 6.7-7.4 (m, 13H, aromatic).

**[0062]** Mass m/z : 388 ($M^+$ + 1), 121($C_8H_{11}N$), 105 ($C_8H_8$)

**[0063]** Anal : Calcd. : $C_{29}H_{36}N_2O_4S$, % C 68.50; % H 7.08%, % N 5.51, Found % C 68.38, % H 6.9, % N 5.4.

## Example 5

**L-Lysine salt of (-)-3-[4-[2-(3,4-dihydro-2H-1,4-benzothiazin-4-yl)ethoxy]phenyl]-2-ethoxy propanoic acid**



**[0064]** (-)-3-[4-[2-(3,4-Dihydro-2H-1,4-benzothiazin-4-yl)ethoxy]phenyl]-2-ethoxy propanoic acid (2.5 g) and isopropanol (25 ml) were added to the 100 ml four necked round bottom flask, fitted with a mechanical stirrer and reflux condenser. The reaction mixture was slowly heated to 45-55°C for complete dissolution of the glassy sticky mass. L-Lysine monohydrate (1.0 g) dissolved in water (5 ml) was added to the reaction mixture at 45-55°C in about 10 min. under stirring. The reaction mixture was maintained for reflux at 80-90°C for 20-24 hrs and monitored the progress of the reaction. The isopropanol was distilled off along with azeotropic distillation of water using Dean-Stark apparatus. Fresh isopropanol (25 ml) was added to the residual reaction mixture and cooled the mixture initially to room temperature followed by cooling to 0-5°C under stirring for 60-90 min. The precipitated product was filtered, dried at 60°C for 2-3 hours to afford the pure L-lysine salt of (-)-3-[4-[2-(3,4-dihydro-2H-1,4-benzothiazin-4-yl)ethoxy]phenyl]-2-ethoxy propanoic acid as off white crystalline, hygroscopic solid (weighs about 2.5 g, yield : 78%, m.p. 142-144°C, purity 97.6 – 99.01% by HPLC).

**[0065]** IR (KBr) $cm^{-1}$ : 3430-3400 (N-H stretch), 2920 (-C-H aliphatic stretch), 2700 - 2200 ($-N^+H_3$ stretch), 1585 ($-COO^-$ stretch), 1400 ($-COO^-$ stretch).

**[0066]** $^1H$ NMR spectrum in DMSO-$d_6$ + TFA (TMS as internal standard) is in confirmation with the assigned structure.

**[0067]** Mass m/z : 388 ($M^+ + 1$), 164 ($C_6H_{16}N_2O_3$), 147 ($C_6H_{13}NO_3$).

**[0068]** Anal. Calcd for $C_{27}H_{41}N_3O_7S$; % C : 58.8; % H 7.44%; % N 7.62%, Found % C 58.7; % H 7.28; % N 7.55.